

**Work Order ID 74492**

Monday, October 03, 2011 10:43:43 AM



Page 1

Item ID: D2432

Accept



Setup Start



Revision ID:

Stop



Item Name: 206 (24") Bearpaw

Start Date: 9/30/2011 Start Qty: 8.00



Cust Item ID:

Required Date: 10/11/2011 Req'd Qty: 8.00

Customer:

Reference:

Approvals:

Process Plan: M.L.J.

Date: 11/10/03 Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2432	Rev F3								
120	FLOW WATER JET	0.00							
	Waterjet								
FLOW CNC Waterjet	Memo Cut Blank as per D2432 File	0.00							
130	HAAS CNC VERTICAL MACHINING #1	0.00							
	HAAS 1								
HAAS CNC vertical machine #1	Memo 1-Inspect material for defects or damage prior to machining 2-Machine as per Folio and Dwg D2432 Identify as D2432F 3-Deburr	0.00							
140	QC2- Inspect parts off machine FAI/FAIB	0.00							
	QC								
Quality Control	Memo	0.00							

Dart Aerospace Ltd

## WORK ORDER CHANGES

W/O:						Approval Chief Eng / Prod Mgr	Approval QC Inspector
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty		

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

## WORK ORDER NON-CONFORMANCE (NCR)

NCR:								
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 74492**

Monday, October 03, 2011 10:43:43 AM



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Item ID: D2432

Accept



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Stop



Item Name: 206 (24") Bearpaw

Start Date: 9/30/2011 Start Qty: 8.00



Cust Item ID:

Required Date: 10/11/2011 Req'd Qty: 8.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

150

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

A.A. 11/10/21

8

0

Quality Control

151

Identify as per dwg &amp; Stock Location: \_\_\_\_\_

0.00



Packaging

Memo

0.00

P112352

Packaging

190

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

11/10/24

ME

11-10-28

Quality Control

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

# Picklist Print

Monday, October 03, 2011 10:43:47 AM

Page 1

Work Order ID: 74492

Parent Item: D2432

Parent Item Name: 206 (24") Bearpaw



Start Date: 9/30/2011

Required Date: 10/11/2011

Start Qty: 8.00

Required Qty: 8.00

## Comments:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MUHMWB10		Purchased	No			120	sf	457.6200	3.7	29.6			



UHMW 1" Black



B1190-03

### Location

### Loc Qty

### Loc Code

MAT018

357.62

117321

76.6

117738

124.3

117819

99.3

118257

57.42

ST

100

118814

100

118

## WORK ORDER CHANGES

W/O:							Approval Chief Eng / Prod Mgr	Approval QC Inspector
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty			

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

## WORK ORDER NON-CONFORMANCE (NCR)

NCR:		Corrective Action Section B				Verification Section C	Approval Chief Eng	Approval QC Inspector
DATE	STEP	Description of NC Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

DART AEROSPACE LTD		Work Order:	74492
Description: Bearpaw		Part Number:	D2432
Inspection Dwg: D2432 Rev: F3		Page 1 of 1	

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Inspection Sheet Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
A 0.063 x 45°	+0.030/-0.010	0.063 x 45°			Vern FKO4	
B 5.500	+/-0.030	5.503			"	
C 0.200	+/-0.030	.205			"	
D 0.25 x 45°	+/-0.030	.25 x 45°			"	
E R0.250	+/-0.030	.250			rad gauge	
F 0.250	+/-0.010	.250			Vern FKO4	
G 0.625	+/-0.030	.632			"	
H 0.375	+/-0.010	.380			"	
I 0.950	+0.030/0.010	.958			"	
J 19.000	+/-0.030	19.000			Tape FKOS	
K 3.14	+/-0.030	3.14			Vern FKO4	
L 3.28	+/-0.030	3.28			"	
M Ø0.260	+0.005/-0.000	.260			"	
N Ø0.93	+/-0.030	.930	—		"	
O .030	+0.030/-0.000	.305	—		"	
P 23.750	+/-0.030	23.75			Tape FKOS	
Q 7.375	+/-0.030	7.380			Vern ENCOZ	
R 4.250	+/-0.010	4.252			Vern FKO4	
S 2.000	+/-0.030	2.020			"	
T 9.000	+/-0.010	9.000	—		M-tape M1-D4	
U 9.000	+/-0.010	9.000	—		"	
V 0.375	+/-0.010	.383			Vern FKO4	

Measured by:	F.K.
Date:	11/10/20

Audited by:	B.A.
Date:	11/10/21

Prototype Approval:	N/A
Date:	

Rev	Date	Change	Revised by	Approved
A	04.01.09	New Issue P/O K10008/D206-559-015	KJ/RF	

W/O:		WORK ORDER CHANGES					Approval	Approval
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Chief Eng / Prod Mgr	QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

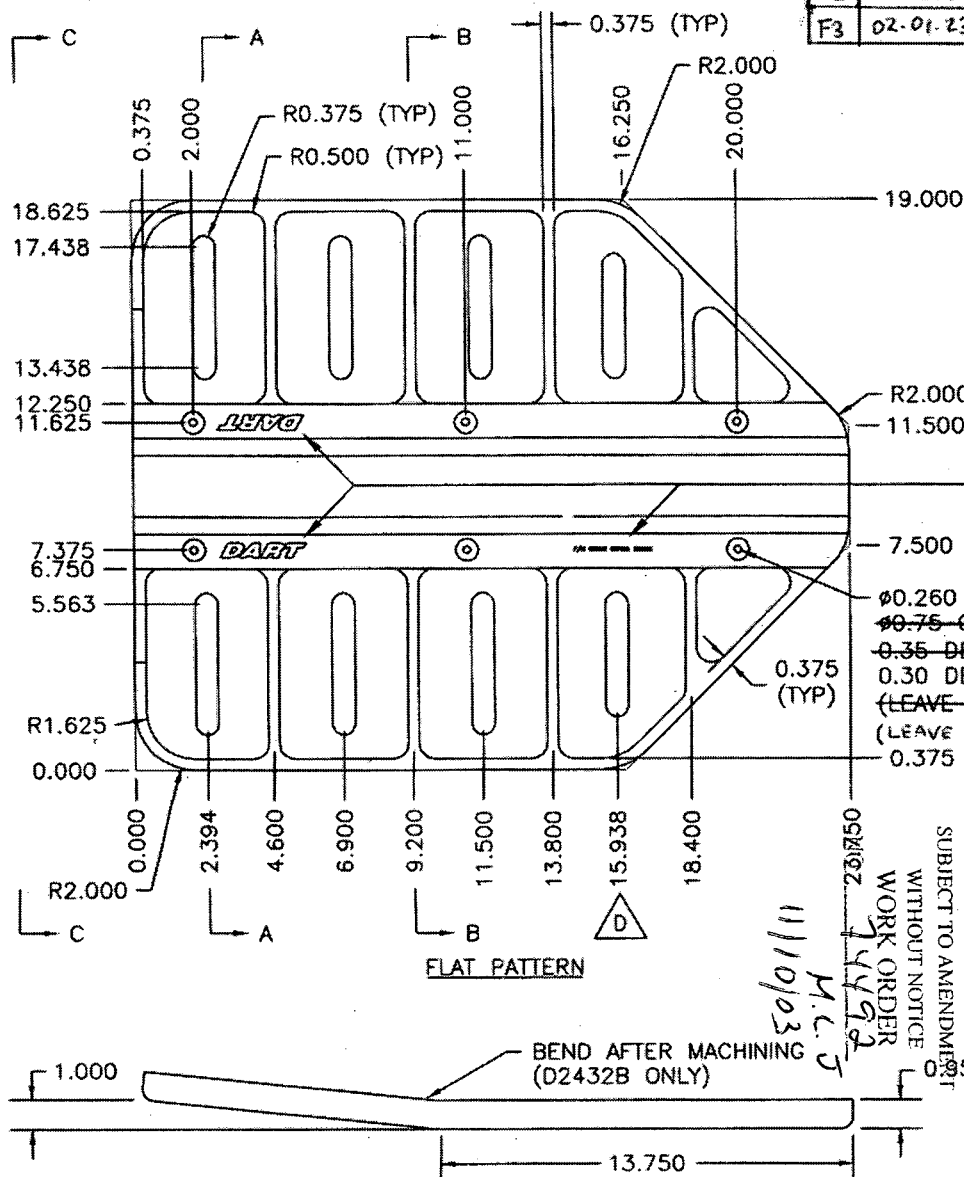
NOTE: Date & initial all entries



GA COAST  
DANISH

93-06-17 KES

F1	99.03.03	ADD DEC 9143	
F2	01.03.28	00.93 WAS 00.75	RF
F3	02.01.23	CLASSIFY CORE DIMS	RF



ENGRAVE LOGO TO MAX  
DEPTH OF 0.012. ENGRAVE  
PART AND BATCH NUMBERS  
TO MAX DEPTH OF 0.010.  
(TYPICAL LOCATION AS  
ILLUSTRATED)

[illegible]

D2432F: FLAT BEARPAW  
D2432B: BENT BEARPAW

MATERIAL: UHMW BLACK PER SPEC CONTROL DRAWING D2689  
1.00 THICK (MACHINE TO 0.950)

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## WORK ORDER CHANGES

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Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

## WORK ORDER NON-CONFORMANCE (NCR)

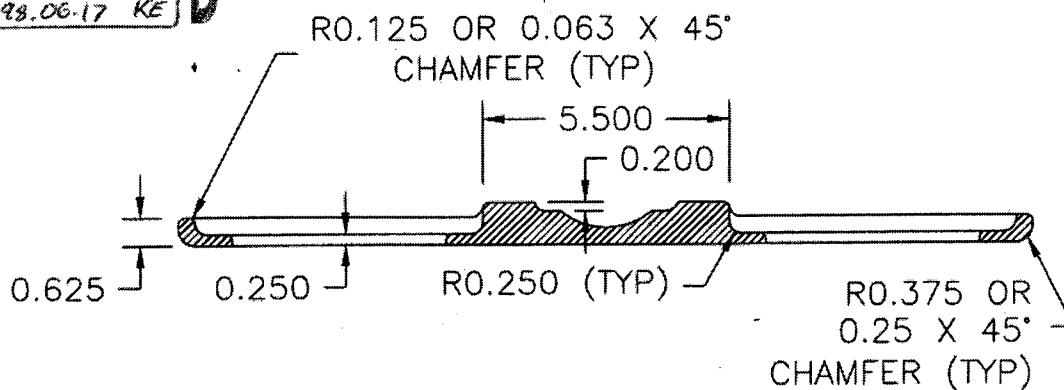
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DATE	STEP	Description of NC Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

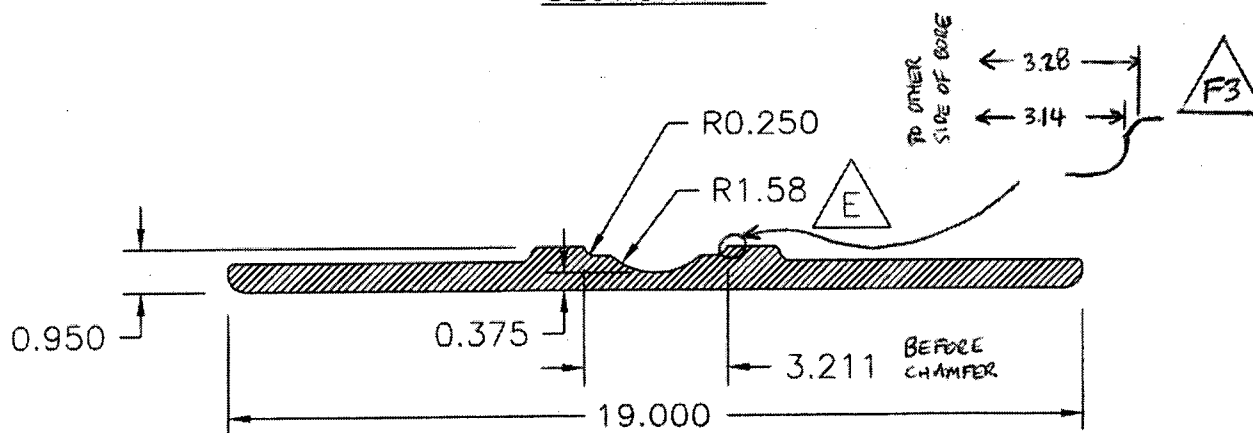


DESIGN KE	DRAWN BY KE	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D2432	REV. F SHEET 2 OF 2
DATE 98.05.12	TITLE BEARPAW		SCALE 1:4

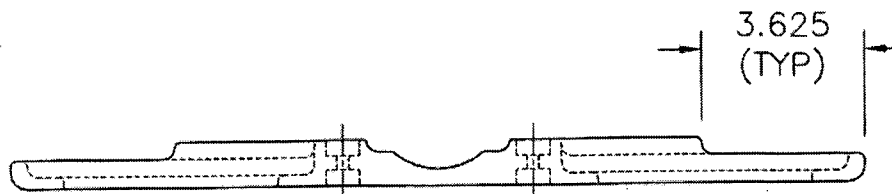
RELEASED  
98.06.17 KE



SECTION A-A



SECTION B-B



SECTION C-C

ebht

## WORK ORDER CHANGES

W/O:							
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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